

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022620**Date Inspected:** 17-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 008560

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 14E. The weld designations reviewed are as follows:

1. SEG3019Z-015
2. SEG3019W-169, 170, 171, 172, 173, 174, 035, 048

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020U-587 located on Anchor Plate to Longitudinal Diaphragm at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR1-2854.

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SMAW welding of weld joint SEG3020AW-092 located on Side Plate to Side Plate panel point 126 to 127 of OBG Segment 14W. ZPMC Welders are identified as 067942 and 067765. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AJ-266 and 267 located on Bottom Plate Stiffener to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB.

SMAW) repair welding of weld joint SEG3020AB-134 located on OBG Segment 14W. ZPMC Welder is identified as 51348. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR20425.

FCAW welding of weld joint SEG3020*-001 located on Deck Panel to Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 218662. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2211-ESAB.

SMAW welding of weld joint SEG3015-001 located on Deck Panel to Deck Panel of OBG Segment 13CW. ZPMC Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint SA3232A-033 located on Deck Panel Diaphragm to Floor Beam of OBG Segment 13CW. ZPMC Welders are identified as 203871 and 048696. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint SEG3015G-001 located on Deck Panel Diaphragm to Deck panel Diaphragm at panel point 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 067701. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015D-001 located on Deck Panel Diaphragm to Deck panel Diaphragm at panel point 124 of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint OBW13A-016 located on Deck Panel to Deck Panel of OBG Segment 13CW to OBG Segment 13BW. ZPMC Welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

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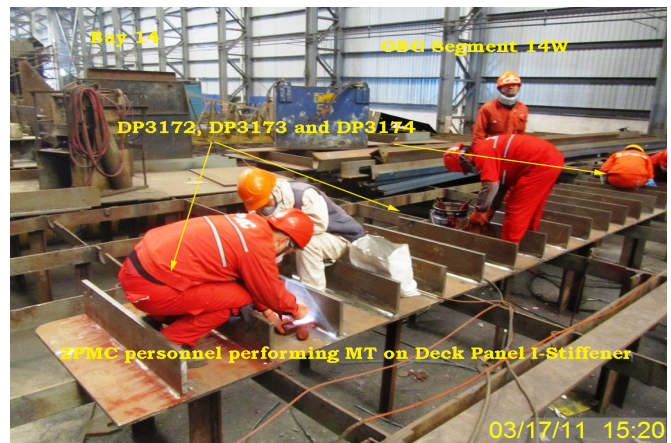
SMAW welding of weld joint OBW13A-013 located on Deck Panel to Deck Panel of OBG Segment 13CW to OBG Segment 13BW. ZPMC Welder is identified as 064461. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015-007 located on Deck Panel to Deck Panel at panel point 123 to 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint SEG3015C-013 located on Deck Panel Diaphragm to Corner Assembly at panel point 124.5 of OBG Segment 13CW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

This QA inspector observed ZPMC personnel performed Magnetic Particle Testing (MT) Deck Panel I-Stiffener of OBG Segment 14W. The Deck panel is identified as DP3172, DP3173 and DP3174. See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer